Dart Aerospace Ltd.

Date: Thursday, 7/20/2006 1:05:43 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 27992		
Estimate Number	: 10530		
P.O. Number	: N/A	**Part Number**	: D2571
This Issue	: 7/20/2006 **S.O. No.** : N/A	**Drawing Number**	: D2571 REV E
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: 7/20/2006 **Type** : MACHINED PARTS	**Drawing Revision**	: E
Previous Run	: 27887	**Material**	: N/A
Written By	:	**Due Date**	: 8/5/2006 **Qty:** ~~16~~ 24 **Um:** Each
Checked & Approved By	: 06.07.21		
Comment	: Est: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D6101007	7075-T7351 8.25X7.75X2.5

Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)
7075-T7351 8.25X7.75X2.5
Make from D6101-007 billet for D2571 B25354 x 1
Ensure that grain is along 7.75" length
Batch No: B23941 x23 J.G 06/08/14

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. B27992 Double check by: BG

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove sharp edges.

J.G/E 06/08/17

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572 /ED 06/08/24

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.G/E 06/08/17

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Mfg / Design Mgr	**Approval** QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Design Mgr	**Approval** QC Inspector
			Initial Design Mgr	**Action Description** Design Mgr	**Sign & Date**			

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** _____ **Date:** 06/08/30

NOTE: Date & initial all entries **QA: N/C Closed:** _____ **Date:** _____

Date: Thursday, 7/20/2006 1:05:44 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 27992 **Part Number:** D2571

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	J.L 06/08/24
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	a.m 06-08-26 (24)
7.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	a.m 06-08-28 (24)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT	06/8/28 (24)
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST479	06/8/28 (24) LB 06/08/28 (24)
10.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21	(24) 06/08/30

Job Completion CL 06/08/29

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Mfg / Design Mgr	**Approval** QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Design Mgr	**Approval** QC Inspector
			Initial Design Mgr	**Action Description** Design Mgr	**Sign & Date**			

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

NOTE: Date & initial all entries **QA: N/C Closed:** _____ **Date:** _____

DART AEROSPACE LTD	Work Order:	27992
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	0.440	0.440	0.440		
B	1.745	1.755		1.746	1.747	1.747	1.747		
C	3.495	3.505		3.500	3.499	3.497	3.496		
D	1.745	1.755		1.746	1.747	1.747	1.746		
E	7.990	8.010		8.002	8.000	8.001	8.002		
F	0.490	0.510		0.496	0.497	0.496	0.497		
G	0.257	0.262	DT8683	✓	0.258	0.258	0.258		
H	0.375	0.380	DT8684	✓	0.376	0.376	0.376		
I	0.490	0.510		0.496	0.497	0.498	0.497		
J	1.174	1.184		1.175	1.179	1.179	1.179		
K	0.558	0.578		0.558	0.568	0.569	0.568		
L	1.174	1.184		1.175	1.177	1.178	1.179		
M	1.490	1.500		1.492	1.497	1.496	1.497		
N	2.495	2.505		2.498	2.497	2.497	2.498		
O	3.869	3.879		3.872	3.871	3.871	3.871		
P	0.115	0.135		0.127	0.126	0.124	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.253	0.254	0.249		
S	0.115	0.135		0.125	0.124	0.125	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.962	2.960	2.960	2.961		
V	0.230	0.250		0.242	0.247	0.246	0.246		
W	0.115	0.135		0.116	0.117	0.117	0.118		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.363	0.363	0.364	0.361		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.620	0.621	0.620		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.246	0.245	0.246		
AE	1.375	1.395		1.385	1.384	1.384	1.389		
AF	0.115	0.135	x	0.135	0.135	0.135	0.135		
AG	0.240	0.280	x	0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.252	0.254	0.253	0.252		
AI	2.000	2.020		2.000	2.000	2.001	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	EB 13.6
Date:	06/08/17

Audited by	JML
Date:	06/08/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27992
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4 & 8	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.747	1.747	1.751	1.750		
C	3.495	3.505		3.497	3.497	3.499	3.499		
D	1.745	1.755		1.747	1.746	1.751	1.750		
E	7.990	8.010		8.001	8.000	8.001	8.002		
F	0.490	0.510		0.499	0.497	0.498	0.499		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.500	0.500	0.498	0.493		
J	1.174	1.184		1.179	1.177	1.178	1.175		
K	0.558	0.578		0.568	0.566	0.563	0.563		
L	1.174	1.184		1.179	1.177	1.178	1.175		
M	1.490	1.500		1.499	1.497	1.485	1.495		
N	2.495	2.505		2.499	2.497	2.499	2.498		
O	3.869	3.879		3.871	3.870	3.872	3.873		
P	0.115	0.135		0.124	0.124	0.125	0.126		
Q	0.115	0.135		0.127	0.126	0.135	0.135		
R	0.240	0.260		0.251	0.249	0.252	0.251		
S	0.115	0.135		0.127	0.126	0.123	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.961	2.960	2.960		
V	0.230	0.250		0.236	0.237	0.234	0.234		
W	0.115	0.135		0.119	0.118	0.119	0.119		
X	0.308	0.313		0.311	0.310	0.310	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	0.361	0.371	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.620	0.621	0.622	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.247	0.244	0.245		
AE	1.375	1.395		1.387	1.384	1.384	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.247	0.246	0.260	0.266		
AH	0.240	0.260		0.250	0.250	0.246	0.246		
AI	2.000	2.020		2.001	2.003	2.003	2.004		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	J.G / EP
Date:	06/08/18 06/08/18

Audited by	J.L
Date:	06/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27992
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4 R	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.747	1.745	1.748		
C	3.495	3.505		3.499	3.500	3.499	3.498		
D	1.745	1.755		1.750	1.747	1.745	1.748		
E	7.990	8.010		8.001	8.002	8.001	8.002		
F	0.490	0.510		0496	0.497	0.496	0.498		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.496	0.494	0.495	0.498		
J	1.174	1.184		1.177	1.176	1.178	1.175		
K	0.558	0.578		0562	0.560	0.561	0563		
L	1.174	1.184		1.177	1.176	1.178	1.175		
M	1.490	1.500		1.493	1.493	1.495	1.495		
N	2.495	2.505		2.499	2.498	2.498	2.496		
O	3.869	3.879		3.872	3.872	3.872	3.869		
P	0.115	0.135		0.127	0.126	0.124	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.252	0.251	0.256		
S	0.115	0.135		0121	0.123	0.125	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.233	0.235	0.233	0.232		
W	0.115	0.135		0.119	0.119	0.120	0.120		
X	0.308	0.313		0.310	0.310	0.310	0311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.366	0.360	0.361	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.624	0.623	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.244	0.247	0.244		
AE	1.375	1.395		1.386	1.384	1.387	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.245	0.249	0.250	0.247		
AI	2.000	2.020		2.001	2.000	2.001	2.001		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EN B
Date:	06/08/21

Audited by	
Date:	06/08/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27992
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	~	~	~	~		
B	1.745	1.755		1.745	1.746	1.747	1.747		
C	3.495	3.505		3.497	3.496	3.500	3.499		
D	1.745	1.755		1.745	1.746	1.746	1.746		
E	7.990	8.010		8.001	8.000	8.000	8.001		
F	0.490	0.510		0.497	0.496	0.498	0.497		
G	0.257	0.262	DT8683	~	~	~	~		
H	0.375	0.380	DT8684	~	~	~	~		
I	0.490	0.510		0.495	0.495	0.496	0.497		
J	1.174	1.184		1.177	1.176	1.178	1.179		
K	0.558	0.578		0.566	0.566	0.567	0.566		
L	1.174	1.184		1.177	1.176	1.178	1.178		
M	1.490	1.500		1.492	1.493	1.494	1.493		
N	2.495	2.505		2.499	2.497	2.496	2.497		
O	3.869	3.879		3.871	3.872	3.871	3.871		
P	0.115	0.135		0.125	0.124	0.123	0.122		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.250	0.249	0.248		
S	0.115	0.135		0.124	0.124	0.123	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.235	0.234	0.235	0.234		
W	0.115	0.135		0.120	0.121	0.122	0.124		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0368	0.367	0.367	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.624	0.624	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0250	0.249	0.251	0.251		
AE	1:375	1.395		1.387	1.388	1.390	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.251	0.251	0.252		
AI	2.000	2.020		2.002	2.002	2.004	2.004		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP/JG
Date:	06/08/24

Audited by	JL
Date:	06/08/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27992
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.749	1.747	1.747	1.749		
C	3.495	3.505		3.499	3.499	3.501	3.497		
D	1.745	1.755		1.749	1.747	1.747	1.745		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		0.491	0.491	0.492	0.493		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.498	0.497	0.497	0.495		
J	1.174	1.184		1.180	1.180	1.178	1.179		
K	0.558	0.578		0.567	0.568	0.567	0.568		
L	1.174	1.184		1.180	1.179	1.179	1.179		
M	1.490	1.500		1.498	1.495	1.494	1.492		
N	2.495	2.505		2.500	2.494	2.497	2.499		
O	3.869	3.879		3.871	3.872	3.871	3.870		
P	0.115	0.135		0.134	0.133	0.134	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.252	0.251	0.252		
S	0.115	0.135		0.124	0.125	0.123	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.962	2.961	2.961	2.960		
V	0.230	0.250		0.247	0.242	0.241	0236		
W	0.115	0.135		0.135	0.134	0.133	0.119		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.370	0.371	0.363	0.370		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.625	0.624	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.252	0.251	0.246		
AE	1.375	1.395		1.387	1.388	1.388	1.388		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.266		
AH	0.240	0.260		0.255	0.255	0.255	0.247		
AI	2.000	2.020		2.004	2.004	2.003	2.002		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	J.G
Date:	06108123

Audited by	J.L
Date:	06/08/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27992
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

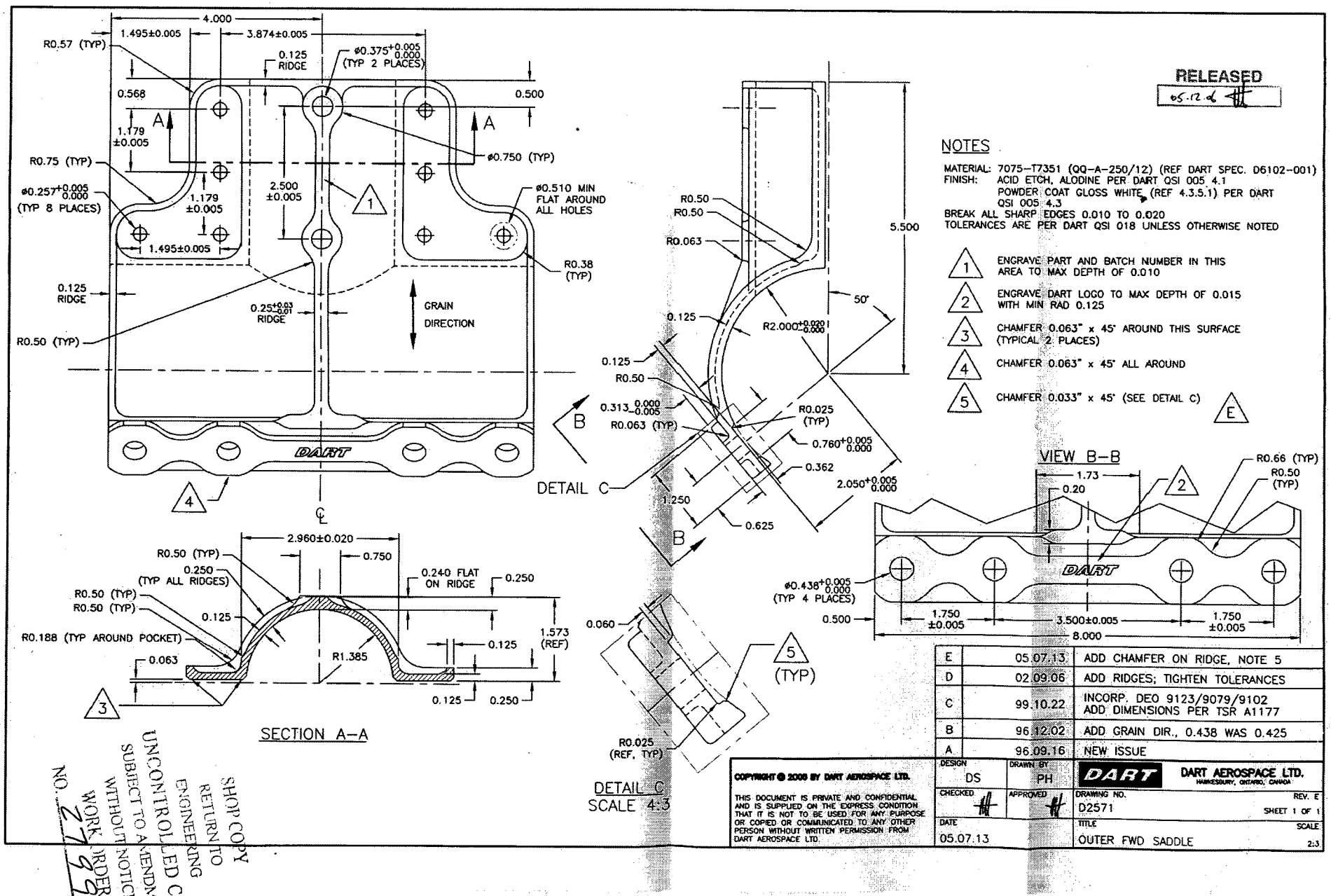
Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4 24	By	Date
A	0.438	0.443	DT8682						
B	1.745	1.755		1.745	1.747	1.745	1.750		
C	3.495	3.505		3.498	3.497	3.498	3.496		
D	1.745	1.755		1.745	1.747	1.745	1.750		
E	7.990	8.010		8.002	8.002	8.003	8.002		
F	0.490	0.510		0.502	0.497	0497	0.502		
G	0.257	0.262	DT8683						
H	0.375	0.380	DT8684						
I	0.490	0.510		0.493	0.494	0.498	0.501		
J	1.174	1.184		1.176	1.177	1.175	1.175		
K	0.558	0.578		0.561	0.565	0.563	0.565		
L	1.174	1.184		1.176	1.177	1.179	1.175		
M	1.490	1.500		1.493	1.491	1.492	1.493		
N	2.495	2.505		2.499	2.497	2.497	2.497		
O	3.869	3.879		3.870	3.869	3.870	3.873		
P	0.115	0.135		0.123	0.127	0.126	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.253	0.253	0.252		
S	0.115	0.135		0.123	0.122	0.122	0.122		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.244	0.238	0.244	0.244		
W	0.115	0.135		0.119	0.119	0.122	0.117		
X	0.308	0.313		0.310	0.310	0.309	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.369	0.367	6365	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.626	0.626	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.245	0.248	0.246		
AE	1.375	1.395		1.389	1.390	1.385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.266	0.260	0.260		
AH	0.240	0.260		0.250	0.246	0.250	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	
Date:	06/08/24

Audited by	JL
Date:	06/08/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	


4.000
1.495±0.005
3.874±0.005
R0.57 (TYP)
0.125 RIDGE
ø0.375 +0.005 0.000 (TYP 2 PLACES)
0.568
0.500
1.179 ±0.005
A
A
R0.75 (TYP)
ø0.750 (TYP)
ø0.257 +0.005 0.000 (TYP 8 PLACES)
1.179 ±0.005
2.500 ±0.005
ø0.510 MIN FLAT AROUND ALL HOLES
1.495±0.005
R0.38 (TYP)
0.125 RIDGE
0.25 +0.03 -0.01 RIDGE
GRAIN DIRECTION
R0.50 (TYP)
DART
4
℄
2.960±0.020
R0.50 (TYP)
0.750
0.250 (TYP ALL RIDGES)
0.240 FLAT ON RIDGE
0.250
R0.50 (TYP)
R0.50 (TYP)
0.125
1.573 (REF)
R0.188 (TYP AROUND POCKET)
0.063
R1.385
0.125
0.125
0.250
3
SECTION A-A
R0.50
R0.50
R0.063
5.500
50°
0.125
R2.000 +0.020 0.000
0.125
R0.50
0.313 0.000 -0.005
R0.063 (TYP)
R0.025 (TYP)
0.760 +0.005 0.000
0.362
2.050 +0.005 0.000
1.250
0.625
B
B
DETAIL C
0.060
5 (TYP)
R0.025 (REF, TYP)
DETAIL C
SCALE 4:3
VIEW B-B
1.73
0.20
2
R0.66 (TYP)
R0.50 (TYP)
ø0.438 +0.005 0.000 (TYP 4 PLACES)
DART
0.500
1.750 ±0.005
3.500±0.005
1.750 ±0.005
8.000
E
NOTES
MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
4 CHAMFER 0.063" x 45° ALL AROUND
5 CHAMFER 0.033" x 45° (SEE DETAIL C)
RELEASED
05.12.6
E 05.07.13 ADD CHAMFER ON RIDGE, NOTE 5
D 02.09.06 ADD RIDGES; TIGHTEN TOLERANCES
C 99.10.22 INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B 96.12.02 ADD GRAIN DIR., 0.438 WAS 0.425
A 96.09.16 NEW ISSUE
COPYRIGHT © 2006 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.
DESIGN DS
DRAWN BY PH
CHECKED
APPROVED
DATE 05.07.13
DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D2571
REV. E
SHEET 1 OF 1
TITLE OUTER FWD SADDLE
SCALE 2:3
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 27992